

•Date: Monday, 09/02/2009 10:15:18 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	RIB ASSY (INBOARD)
Job Number :	45609		
Estimate Number :	13661		
P.O. Number :		Part Number :	D3827041
This Issue :	09/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3827 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	44771	Drawing Revision :	A
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	13/02/2009
Written By :		Qty:	4
Checked & Approved By :	JUD 09.02.09	Um:	Each
Comment :	Est Rev:A 08-12-01 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D37591	Bushing
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing B447:7 → 4 B45794 → 1x

batch: ~~111051~~ B44059 → 7

PD 09.02.17

~~SAD 09.02.13~~ (4)

✓ 2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 8.4000 f(s)/Unit Total: 33.6000 f(s)

304 SQ Tube .75x.75x.065W

batch: M110561

SAD 09-02-13 (4)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAD 09-02-13 (4)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09.02.13 (4)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- weld bushing in rib as per dwg D3827

A/R ER316 S.S. Rod Batch: M107051

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 10:15:18 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (INBOARD)

Job Number: 45609

Part Number: D3827041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- grind weld flush

3- deburr if necessary

PD 09-02-17 (9)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-02-23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-23 (x8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WAL

PD 09-02-24 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24

Job Completion



09-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

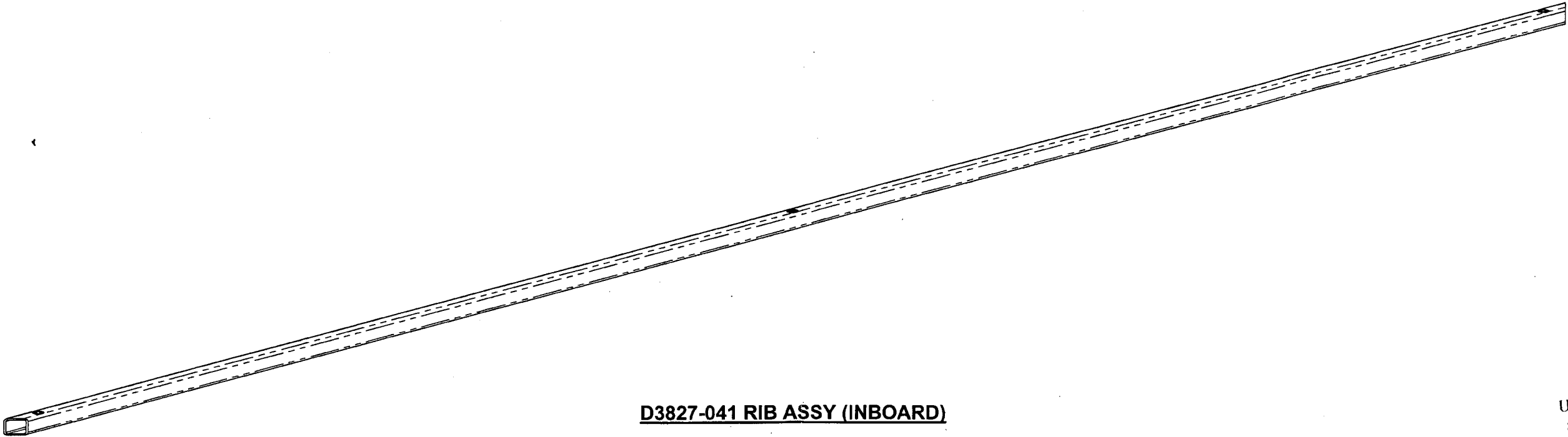
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



D3827-041 RIB ASSY (INBOARD)

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WITHOUT NOTICE
WORK ORDER
NO. 45609

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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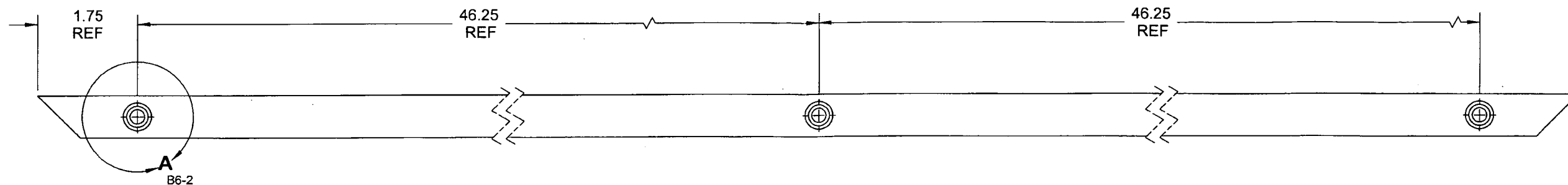
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B

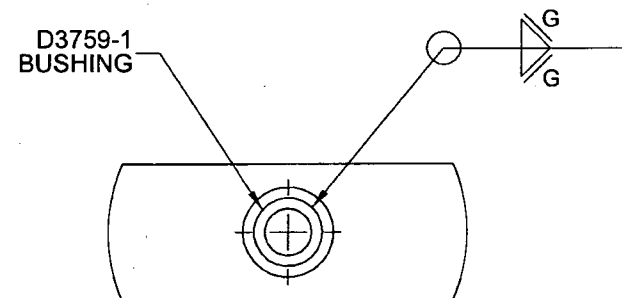
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A

A



D3827-041 RIB ASSY (INBOARD)

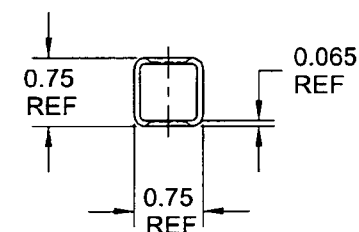


DETAIL A
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3 PL

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